(November 1988)
w/Not. #6
(August 1994)
Superseding
CEGS-03100
(October 1987)
typed 2 Dec 94

SECTION 03100 - STRUCTURAL CONCRETE FORMWORK

PART 1 - GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by basic designation only.

AMERICAN CONCRETE INSTITUTE (ACI)

ACI 347R (1988) Guide to Formwork for Concrete

DEPARTMENT OF COMMERCE (DOC)

DOC PS 1 (1983) Construction and Industrial Plywood

1.2 SUBMITTALS

Government approval is required for submittals with a "GA" designation; submittals having an "FIO" designation are for information only. The following shall be submitted in accordance with Section 01300 SUBMITTAL DESCRIPTIONS:

SD-01 Data\

Design\; *GA*\.

Design analysis and calculations for form design and methodology used in the design.

Concrete Formwork\; *FIO*\.

Manufacturer's data including literature describing form materials, accessories, and form releasing agents.

SD-04 Drawings\

Concrete Formwork\; *FIO*\.

Drawings showing details of formwork including, dimensions of fiber voids, joints, supports, studding and shoring, and sequence of form and shoring removal.

SD-06 Instructions\

Form Releasing Agents\; *FIO*\.

Manufacturer's recommendation on method and rate of application of form releasing agents.

1.3 DESIGN

Formwork shall be designed in accordance with methodology of ACI 347R for anticipated loads, lateral pressures, and stresses. Forms shall be capable of producing a surface which meets the requirements of the class of finish specified in Section 03300 CONCRETE FOR BUILDING CONSTRUCTION. Forms shall be capable of withstanding the pressures resulting from placement and vibration of concrete.

1.4 STORAGE AND HANDLING

Fiber voids shall be stored above ground level in a dry location. Fiber voids shall be kept dry until installed and overlaid with concrete.

PART 2 - PRODUCTS

2.1 FORM MATERIALS

2.1.1 Forms For Class B Finish

Forms for Class B finished surfaces shall be plywood panels conforming to DOC PS 1, Grade B-B concrete form panels, Class I or II. Other form materials or liners may be used provided the smoothness and appearance of concrete produced will be equivalent to that produced by the plywood concrete form panels.

2.1.2 Forms For Class D Finish

Forms for Class D finished surfaces, except where concrete is placed against earth, shall be wood or steel or other approved concrete form material.

2.1.3 Form Ties

Form ties shall be factory-fabricated metal ties, shall be of the removable or internal disconnecting or snap-off type, and shall be of a design that will not permit form deflection and will not spall concrete upon removal. Solid backing shall be provided for each tie. Except where removable tie rods are used, ties shall not leave holes in the concrete surface less than 1/4 inch nor more than 1 inch deep and not more than 1 inch in diameter. Removable tie rods shall be not more than 1-1/2 inches in diameter.

2.1.4 Form Releasing Agents

Form releasing agents shall be commercial formulations that will not bond with, stain or adversely affect concrete surfaces. Agents shall not impair subsequent treatment of concrete surfaces depending upon bond or adhesion nor impede the wetting of surfaces to be cured with water or curing compounds.

PART 3 - EXECUTION

3.1 INSTALLATION

3.1.1 Formwork

Forms shall be mortar tight, properly aligned and adequately supported to produce concrete surfaces meeting the surface requirements specified in Section 03300 CONCRETE FOR BUILDING CONSTRUCTION and conforming to construction tolerance given in TABLE 1. Where concrete surfaces are to have a Class A or Class B finish, joints in form panels shall be arranged as approved. Where forms for continuous surfaces are placed in successive units, care shall be taken to fit the forms over the completed surface so as to obtain accurate alignment of the surface and to prevent leakage of mortar. Forms shall not be reused if there is any evidence of surface wear and tear or defects which would impair the quality of the surface. Surfaces of forms to be reused shall be cleaned of mortar from previous concreting and of all other foreign material before reuse. Form ties that are to be completely withdrawn shall be coated with a nonstaining bond breaker.

3.2 CHAMFERING

Except as otherwise shown, external corners that will be exposed shall be chamfered, beveled, or rounded by moldings placed in the forms.

3.3 COATING

Forms for Class A and Class B finished surfaces shall be coated with a form releasing agent before the form or reinforcement is placed in final position. The coating shall be used as recommended in the manufacturer's printed or written instructions. Forms for Class D finished surfaces may be wet with water in lieu of coating immediately before placing concrete, except that in cold weather with probable freezing temperatures coating shall be mandatory. Surplus coating on form surfaces and coating on reinforcing steel and construction joints shall be removed before placing concrete.

3.4 REMOVAL OF FORMS

Forms shall be removed in a manner that will prevent injury to the concrete and ensure the complete safety of the structure. Formwork for columns, walls, side of beams and other parts not supporting the weight of concrete may be removed when the concrete has attained sufficient strength to resist damage from the removal operation but not before at least 24 hours has elapsed since concrete placement. Supporting forms and shores shall not be removed from beams, floors and walls until the structural units are strong enough to carry their own weight and any other construction or natural loads. In no case will supporting forms or shores be removed before the concrete strength has reached 70 percent of design strengths as determined by field cured cylinders or other approved methods. This strength shall be demonstrated by job-cured test specimens, and by a structural analysis considering the proposed loads in relation to these test strengths and the strength of forming and shoring system. The job-cured test specimens for form removal purposes shall be provided in numbers as directed and shall be in addition to those required for concrete quality control. The specimens shall be removed from molds at the age of 24 hours and shall receive, insofar as possible, the same curing and protection as the structures they represent.

TABLE 1
TOLERANCES FOR FORMED SURFACES

1. Variations from the plumb: In any 10 feet of length ----- 1/4 inch

a. In the lines and surfaces of piers, walls	Maximum for entire length ----- 1 inch and in arises
b. For control-joint grooves, and other conspicuous lines	In any 20 feet of length ----- 1/4 inch Maximum for entire length ---- 1/2 inch
2. Variation from the level or from the grades indicated on the drawings:	In any 10 feet of length ----- 1/4 inch In any bay or in any 20 feet of length ---------- 3/8 inch
a. In ceilings, and in arises	Maximum for entire length ---- 3/4 inch measured before removal of supporting shores
b. In horizontal grooves and other conspicuous lines	In any bay or in any 20 feet of length ---------- 1/4 inch Maximum for entire length ---- 1/2 inch
3. Variation of the linear building lines from established position in plan	In any 20 feet ---------- 1/2 inch Maximum ---------- 1 inch
4. Variation in the sizes and locations of sleeves, floor openings, and wall opening	Minus ---------- 1/4 inch Plus ---------- 1/2 inch
5. Variation in the thickness of slabs and walls	Minus ---------- 1/4 inch Plus ---------- 1/2 inch

6. Footings:		
a.	Variation of dimensions in plan	Minus ---------- 1/2 inch Plus ---------- 2 inches when formed or plus 3 inches when placed against unformed excavation
b.	Misplacement of eccentricity	2 percent of the footing width in the direction of misplacement but not more than ---------- 2 inches
c.	Reduction in thickness	Minus ---------- 5 percent of specified thickness
8. Variation in steps:		Riser ---------- 1/8 inch
a.	In a flight of stairs	Tread ---------- 1/4 inch
b.	In consecutive steps	Riser ---------- 1/16 inch Tread ---------- 1/8 inch

- - o 0 o - -

CEGS-03200
(November 1988)
W/Notice 5
(May 1994)
Superseding
CEGS-03200
(October 1987)
typed 4 Oct 94

SECTION 03200 - CONCRETE REINFORCEMENT

PART 1 - GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by basic designation only.

AMERICAN CONCRETE INSTITUTE (ACI)

ACI 318/318R	(1989; Rev 1992; Errata) Building Code Requirements for Reinforced Concrete.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM A 53	(1990b) Pipe, Steel, Black and Hot-Dipped, Zinc-Coated Welded and Seamless.
ASTM A 82	(1990a) Steel Wire, Plain, for Concrete Reinforcement.
ASTM A 184	(1990) Fabricated Deformed Steel Bar Mats for Concrete Reinforcement.
ASTM A 185	(1990a) Steel Welded Wire Fabric, Plain, for Concrete Reinforcement.
ASTM A 497	(1990b) Steel Welded Wire Fabric, Deformed, for Concrete Reinforcement.
ASTM A 499	(1989) Steel Bars and Shapes, Carbon Rolled from "T" Rails.
ASTM A 615	(1992b) Deformed and Plain Billet-Steel Bars for Concrete Reinforcement.
ASTM A 675	(1990a) Steel Bars, Carbon, Hot-Wrought, Special Quality, Mechanical Properties.
ASTM A 706	(1992b) Low-Alloy Steel Deformed Bars for Concrete Reinforcement.

AMERICAN WELDING SOCIETY (AWS)

AWS D1.4 (1992) Structural Welding Code - Reinforcing Steel.

CONCRETE REINFORCING STEEL INSTITUTE (CRSI)

CRSI MSP-1 (1990) Manual of Standard Practice.

1.2 SUBMITTALS

Government approval is required for submittals with a "GA" designation; submittals having an "FIO" designation are for information only. The following shall be submitted in accordance with SECTION: 01300 - SUBMITTAL DESCRIPTIONS:

SD-04, Drawings\

Concrete Reinforcement System\; *GA*\.

Detail drawings showing reinforcing steel schedules, sizes, grades, and splicing and bending details. Drawings shall show support details including types, sizes and spacing.

SD-08, Statements\

Qualifications\; *FIO*\.

A list of names of qualified welders.

SD-13, Certificates\

Reinforcing Steel\; *FIO*\.

Certified copies of mill reports attesting that the reinforcing steel furnished meets the requirements specified, prior to the installation of reinforcing steel.

1.3 QUALIFICATIONS

Welders shall be qualified in accordance with AWS D1.4. Qualification test shall be performed at the worksite and the Contractor shall notify the Contracting Officer 24 hours prior to conducting tests. Special welding procedures and welders qualified by others may be accepted as permitted by AWS D1.4.

1.4 DELIVERY AND STORAGE

Reinforcement and accessories shall be stored off the ground on platforms, skids, or other supports.

PART 2 - PRODUCTS

2.1 DOWELS

Dowels shall conform to ASTM A 675, Grade 80, or ASTM A 499. Steel pipe conforming to ASTM A 53, Schedule 80, may be used as dowels provided the ends are closed with metal or plastic inserts or with mortar.

2.2 FABRICATED BAR MATS

Fabricated bar mats shall conform to ASTM A 184.

2.3 REINFORCING STEEL

Reinforcing steel shall be deformed bars conforming to ASTM A 615 or ASTM A 706, grades and sizes as indicated. Cold drawn wire used for spiral reinforcement shall conform to ASTM A 82.

2.4 WELDED WIRE FABRIC

Welded wire fabric shall conform to ASTM A 185 or ASTM A 497.

2.5 WIRE TIES

Wire ties shall be 16 gauge or heavier black annealed steel wire.

2.6 SUPPORTS

Bar supports for formed surfaces shall be designed and fabricated in accordance with CRSI MSP-1 and shall be steel or precast concrete blocks. Precast concrete blocks shall have wire ties and shall be not less than 4 by 4 inches when supporting reinforcement on ground. Precast concrete block shall have compressive strength equal to that of the surrounding concrete. Where concrete formed surfaces will be exposed to weather or where surfaces are to be painted, steel supports within 1/2-inch of concrete surface shall be galvanized, plastic protected or of stainless steel. Concrete supports used in concrete exposed to view shall have the same color and texture as the finish surface. For slabs on grade, supports shall be precast concrete blocks, plastic coated steel fabricated with bearing plates, or specifically designed wire-fabric supports fabricated of plastic.

PART 3 - EXECUTION

3.1 REINFORCEMENT

Reinforcement shall be fabricated to shapes and dimensions shown and shall conform to the requirements of ACI 318/318R. Reinforcement shall be cold bent unless otherwise authorized. Bending may be accomplished in the field or at the mill. Bars shall not be bent after embedment in concrete. Safety caps shall be placed on all exposed ends of vertical concrete reinforcement bars that pose a danger to life safety. Wire tie ends shall face away from the forms.

3.1.1 Placement

Reinforcement shall be free from loose rust and scale, dirt, oil, or other deleterious coating that could reduce bond with the concrete. Reinforcement shall be placed in accordance with ACI 318/318R at locations shown plus or minus one bar diameter. Reinforcement shall not be continuous through expansion joints and shall be as indicated through construction or contraction joints. Concrete coverage shall be as indicated or as required by ACI 318/318R. If bars are moved more than one bar diameter to avoid interference with other reinforcement, conduits or embedded items, the resulting arrangement of bars, including additional bars required to meet structural requirements, shall be approved before concrete is placed.

3.1.1.1 Ribbed Mat Foundations

Reinforcement shall be continuous through construction joints, but not through expansion and contraction joints.

(Authority: 3078 DR ("Deficiency in Guide Spec 03300") dated 20 Mar 1984 and approved for regional change for insertion of ribbed mat foundation requirements, 23 Apr 1984) (May 1984)

3.1.2 Splicing

Splices of reinforcement shall conform to ACI 318/318R and shall be made only as required or indicated. Splicing shall be by lapping or by mechanical or welded butt connection; except that lap splices shall not be used for bars larger than No. 11 unless otherwise indicated. Welding shall conform to AWS D1.4. Welded butt splices shall be full penetration butt welds. Lapped bars shall be placed in contact and securely tied or spaced transversely apart to permit the embedment of the entire surface of each bar in concrete. Lapped bars shall not be spaced farther apart than one-fifth the required length of lap or 6 inches. Mechanical butt splices shall be in accordance with the recommendation of the manufacturer of the mechanical splicing device. Butt splices shall develop 125 percent of the specified minimum yield tensile strength of the spliced bars or of the smaller bar in transition splices. Bars shall be flame dried before butt splicing. Adequate jigs and clamps or other devices shall be provided to support, align, and hold the longitudinal centerline of the bars to be butt spliced in a straight line.

3.2 WELDED-WIRE FABRIC

Welded-wire fabric shall be placed in slabs as indicated. Fabric placed in slabs on grade shall be continuous between expansion, construction, and contraction joints. Fabric placement at joints shall be as indicated. Lap splices shall be made in such a way that the overlapped area equals the distance between the outermost crosswires plus 2 inches. Laps shall be staggered to avoid continuous laps in either direction. Fabric shall be wired or clipped together at laps at intervals not to exceed 4 feet. Fabric shall be positioned by the use of supports.

3.3 DOWELS

Dowels shall be installed in slabs on grade at locations indicated and at right angles to joint being doweled. Dowels shall be accurately positioned and aligned parallel to the finished concrete surface before concrete placement. Dowels shall be rigidly supported during concrete placement. One end of dowels shall be coated with a bond breaker.

- - o 0 o - -

CEGS-03250
(December 1988)
w/Not. #2
(February 1993)
Superseding
CEGS-03250
(October 1987)
typed 4 May 94

SECTION 03250 - EXPANSION JOINTS, CONTRACTION JOINTS, AND WATERSTOPS

PART 1 - GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by basic designation only.

AMERICAN HARDBOARD ASSOCIATION (AHA)

AHA A135.4	(1982; R 1988) Basic Hardboard

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 1751	(1983; R 1991) Preformed Expansion Joint Filler for Concrete Paving and Structural Construction (Nonextruding and Resilient Bituminous Types)
ASTM D 1752	(1984; R 1992) Preformed Sponge Rubber and Cork Expansion Joint Fillers for Concrete Paving and Structural Construction
ASTM D 2628	(1991) Preformed Polychloroprene Elastomeric Joint Seals for Concrete Pavements
ASTM D 2835	(1989) Lubricant for Installation of Preformed Compression Seals in Concrete Pavements

CORPS OF ENGINEERS (COE)

COE CRD-C 513	(1974) Corps of Engineers Specifications for Rubber Waterstops
COE CRD-C 572	(1974) Corps of Engineers Specifications for Polyvinylchloride Waterstops

FEDERAL SPECIFICATIONS (FS)

FS SS-S-1401	(Rev C; Notice 1) Sealant, Joint, Non-Jet-Fuel-Resistant, Hot-Applied, for Portland Cement and Asphalt Concrete Pavements

1.2 SUBMITTALS

Government approval is required for submittals with a "GA" designation; submittals having an "FIO" designation are for information only. The following shall be submitted in accordance with Section 01300 SUBMITTAL DESCRIPTIONS:

SD-01 Data\

Materials\; *FIO*\.

Manufacturer's catalog data and manufacturer's recommended instructions for splicing of waterstops.

SD-13 Certificates\

Materials\; *FIO*\.

Certificates of compliance stating that the joint filler and sealant materials and waterstops conform to the requirements specified.

1.3 DELIVERY AND STORAGE

Material delivered and placed in storage shall be stored off the ground and protected from moisture, dirt, and other contaminants. Sealants shall be delivered in the manufacturer's original unopened containers. Sealants whose shelf life has expired shall be removed from the site.

PART 2 - PRODUCTS

2.1 CONTRACTION-JOINT STRIPS

Contraction-joint strips shall be 1/8-inch thick tempered hardboard conforming to AHA A135.4, Class 1. In lieu of hardboard strips, rigid polyvinylchloride (PVC) insert strips specifically designed to induce controlled cracking in slabs on grade may be used. Such insert strips shall have removable top section.

2.2 EXPANSION-JOINT FILLER

Expansion-joint filler shall be premolded material conforming to ASTM D 1751 or ASTM D 1752. Unless otherwise indicated, filler material shall be 3/8-inch thick and of a width applicable for the joint formed.

2.3 JOINT SEALANT

Joint sealant shall conform to the following:

2.3.1 Preformed Polychloroprene Elastomeric Joint Seals

ASTM D 2628.

2.3.2 Lubricant for Installation of Preformed Compression Seals

ASTM D 2835.

2.4 WATERSTOPS

Waterstops shall conform to COE CRD-C 513 or COE CRD-C 572.

PART 3 - EXECUTION

3.1 JOINTS

Joints shall be installed at locations indicated and as authorized.

3.1.1 Contraction Joints

Contraction joints may be constructed by inserting tempered hardboard strips or rigid PVC insert strips into the plastic concrete or by cutting the concrete with a saw after concrete has set. Joints shall be approximately 1/8-inch wide and shall extend into the slab approximately one-fourth the slab thickness but not less than 1 inch.

3.1.1.1 Joint Strips

Strips shall be of the required dimensions and as long as practicable. After the first floating, the concrete shall be grooved with a tool at the joint locations. The strips shall be inserted in the groove and depressed until the top edge of the vertical surface is flush with the surface of the slab. The slab shall be floated and finished as specified. Working of the concrete adjacent to the joint shall be the minimum necessary to fill voids and consolidate the concrete. Where indicated, the top portion of the strip shall be sawed out after the curing period to form a recess for sealer. The removable section of PVC strips shall be discarded and the insert left in place. Means shall be provided to insure true alignment of the strips is maintained during insertion.

3.1.1.2 Sawed Joints

Joint sawing shall be early enough to prevent uncontrolled cracking in the slab, but late enough that this can be accomplished without appreciable spalling. Concrete-sawing machines shall be adequate in number and power, and with sufficient replacement blades to complete the sawing at the required rate. Joints shall be cut to true alignment and shall be cut in sequence of concrete placement. Sludge and cutting debris shall be removed.

3.1.2 Expansion Joints

Premolded expansion joint filler shall be used in expansion and isolation joints in slabs around columns and between slabs on grade and vertical surfaces where indicated. The filler shall extend the full slab depth, unless otherwise indicated. The edges of the joint shall be neatly finished with an edging tool of 1/8-inch radius, except where a resilient floor surface will be applied. Where the joint is to receive a sealant, the filler strips shall be installed at the proper level below the finished floor with a slightly tapered, dressed-and-oiled wood strip temporarily secured to the top thereof to form a recess 3/4-inch deep to be filled with sealant. The wood strip shall be removed after the

concrete has set. In lieu of the wood strip a removable expansion filler cap designed and fabricated for this purpose may be used.

3.1.3 Joint Sealant

Sawed contraction joints and expansion joints in slabs shall be filled with joint sealant, unless otherwise shown. Types and locations of sealants shall be as indicated. Joint surfaces shall be clean, dry, and free of oil or other foreign material which would adversely affect the bond between sealant and concrete. Joint sealant shall be applied as recommended by the manufacturer of the sealant. Joints sealed with field molded sealant shall be completely filled with sealant.

3.2 WATERSTOPS

Waterstops shall be of the type indicated and shall be installed at the locations shown to form a continuous water-tight diaphragm. Adequate provision shall be made to support and completely protect the waterstops during the progress of the work. Any waterstop punctured or damaged shall be repaired or replaced. Splices shall be made in conformance with the recommendations of the waterstop manufacturer. Continuity of cross sectional features shall be maintained across the splice. Splices showing evidence of separation after bending shall be remade.

- - o 0 o - -

-- End of Section --

CEGS-03300
(December 1988)
w/Not. #8
(February 1994)
Superseding
CEGS-03300
(October 1987)
typed 25 May 94

SECTION 03300 - CONCRETE FOR BUILDING CONSTRUCTION

PART 1 - GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by basic designation only.

AMERICAN CONCRETE INSTITUTE (ACI)

ACI 117	(1990; Errata) Standard Tolerances for Concrete Construction and Materials
ACI 211.1	(1991) Standard Practice for Selecting Proportions for Normal, Heavyweight, and Mass Concrete
ACI 301	(1989) Structural Concrete for Buildings
ACI 305R	(1991) Hot Weather Concreting
ACI 318	(1989; Rev 1992; Errata) Building Code Requirements for Reinforced Concrete

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM C 31	(1991) Making and Curing Concrete Test Specimens in the Field
ASTM C 33	(1990) Concrete Aggregates
ASTM C 39	(1986) Compressive Strength of Cylindrical Concrete Specimens
ASTM C 42	(1990) Obtaining and Testing Drilled Cores and Sawed Beams of Concrete
ASTM C 94	(1992) Ready-Mixed Concrete
ASTM C 109	(1992) Compressive Strength of Hydraulic Cement Mortars (Using 2-in. or 50-mm Cube Specimens)
ASTM C 143	(1990a) Slump of Hydraulic Cement Concrete
ASTM C 150	(1992) Portland Cement

ASTM C 171	(1992) Sheet Materials for Curing Concrete
ASTM C 172	(1990) Sampling Freshly Mixed Concrete
ASTM C 173	(1978) Air Content of Freshly Mixed Concrete by the Volumetric Method
ASTM C 192	(1990a) Making and Curing Concrete Test Specimens in the Laboratory
ASTM C 231	(1991b) Air Content of Freshly Mixed Concrete by the Pressure Method
ASTM C 260	(1986) Air-Entraining Admixtures for Concrete
ASTM C 309R	(1991) Guide for Consolidation of Concrete
ASTM C 494	(1992) Chemical Admixtures for Concrete
ASTM C 595	(1992a) Blended Hydraulic Cements
ASTM C 597	(1983; R 1991) Pulse Velocity Through Concrete
ASTM C 618	(1992a) Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral Admixture in Portland Cement Concrete
ASTM C 803	(1990) Penetration Resistance of Hardened Concrete
ASTM C 805	(1985) Rebound Number of Hardened Concrete
ASTM C 989	(1989) Ground Granulated Blast-Furnace Slag for Use in Concrete and Mortars
ASTM C 1017	(1992) Chemical Admixtures for Use in Producing Flowing Concrete
ASTM C 1107	(1991a) Packaged Dry, Hydraulic-Cement Grout (Nonshrink)
ASTM D 98	(1987) Calcium Chloride
ASTM E 96	(1993) Water Vapor Transmission of Materials

FEDERAL SPECIFICATIONS (FS)

FS CCC-C-467	(Rev C) Cloth, Burlap, Jute (or Kenaf)
FS SS-S-200	(Rev E; Am 1) Sealants, Joint, Two-Component, Jet-Blast-Resistant, Cold-Applied, for Portland Cement Concrete Pavement\F
FS SS-S-1401	(Rev C; Notice 1) Sealant, Joint, Non-Jet-Fuel-Resistant, Hot-Applied, for Portland Cement and Asphalt Concrete Pavements\F

NATIONAL READY-MIXED CONCRETE ASSOCIATION (NRMCA)

NRMCA CPMB 100	(1990) Concrete Plant Standards
NRMCA QC 3	(1984) Quality Control Manual: Section 3, Plant Certifications Checklist: Certification of Ready-Mixed Concrete Production Facilities
NRMCA TMMB	(1989) Truck Mixer, and Agitator Standards

1.2 SUBMITTALS

Government approval is required for submittals with a "GA" designation; submittals having an "FIO" designation are for information only. The following shall be submitted in accordance with Section 01300 SUBMITTAL DESCRIPTIONS:

SD-08 Statements\

Proportions of Mix\; *GA*\.

The results of trial mix along with a statement giving the maximum nominal coarse aggregate size and the proportions of all ingredients that will be used in the manufacture of each strength of concrete, at least 14 days prior to commencing concrete placing operations. Aggregate weights shall be based on the saturated surface dry condition. The statement shall be accompanied by test results from an independent commercial testing laboratory, attesting that the proportions selected will produce concrete of the qualities indicated. No substitutions shall be made in the materials used in the work without additional tests to show that the quality of the concrete is satisfactory.

SD-09 Reports\

Sampling and Testing\; *FIO*\.

Certified copies of laboratory test reports, including all test data, for aggregate, admixtures, and curing materials. These tests shall be made by an approved commercial laboratory or by a laboratory maintained by the manufacturers of the materials.

SD-13 Certificates\

Cementitious Materials\; *FIO*\.

Manufacturer's certification of compliance, accompanied by mill test reports attesting that the materials meet the requirements of the specification under which it is furnished, for cement, pozzolan, and ground iron blast-furnace slag. No cement, pozzolan, or slag shall be used until notice of acceptance has been given. Cement, pozzolan, and slag may be subjected to check testing by the Government from samples obtained at the mill, at transfer points, or at the project site.

1.3 GENERAL REQUIREMENTS

Tolerances for concrete construction and materials shall be in accordance with ACI 117.

1.3.1 Strength Requirements

Structural concrete for all work shall have a 28-day compressive strength of 3000 pounds per square inch.

1.3.2 Air Entrainment

Concrete in ground floor slabs shall contain from 3 to 5 percent total air. Concrete in elevated floor slab shall not be air entrained.

1.3.3 Special Properties

Concrete may contain other admixtures, such as water reducers, superplasticizers, or set retarding agents to provide special properties to the concrete, if approved.

1.3.4 Slump

Slump shall be within the following limits:

Structural Element	Slump in inches	
	Minimum	Maximum
Walls, columns and beams	2	4
Foundation walls, substructure walls, footings, pavement, and slabs	1	3
Any structural concrete approved for placement by pumping	None	6

Where use of superplasticizers are approved to produce flowing concrete these slump requirements do not apply.

1.3.5 Technical Service for Specialized Concrete

The service of a technical representative shall be obtained to oversee proportioning, batching, mixing, placing, consolidating and finishing of specialized structural concrete, such as lightweight or flowing concrete until field controls indicate concrete of specified quality is furnished.

1.4 PROPORTIONS OF MIX

1.4.1 Mixture Proportioning, Normal Weight Concrete

Trial batches shall contain materials proposed to be used in the project. Trial mixtures having proportions, consistencies and air content suitable for the work shall be made based on methodology described in ACI 211.1, using at least three different water-cement ratios. Trial mixes shall be proportioned to produce concrete strengths specified. In the case where ground iron blast-furnace slag is used, the weight of the slag will be substituted in the equations for the term P which is used to denote the weight of pozzolan. Trial mixtures shall be designed for maximum permitted slump and air content. The temperature of concrete in each trial batch shall be reported. For each water-cement ratio at least three test cylinders for each test age shall be made and cured in accordance with ASTM C 192. They shall be tested at 7 and 28 days in accordance with ASTM C 39 . From these test results a curve shall be plotted showing the relationship between water-cement ratio and strength. For each strength of concrete the maximum allowable water-cement ratio shall be that shown by these curves to produce an average strength as specified in paragraph AVERAGE STRENGTH.

1.4.2 Average Strength

In meeting the strength requirements specified, the selected mixture proportion shall produce an average compressive strength exceeding the specified strength by the amount indicated below. Where a concrete production facility has test records, a standard deviation shall be established. Test records from which a standard deviation is calculated shall represent materials, quality control procedures, and conditions similar to those expected; shall represent concrete produced to meet a specified strength or strengths within 1000 psi of that specified for proposed work; and shall consist of at least 30 consecutive tests. A strength test shall be the average of the strengths of two cylinders made from the same sample of concrete and tested at 28 days or at other test age designated for determination of the specified strength.

1.4.2.1 Test Records Exceeding 29

Required average compressive strength used as the basis for selection of concrete proportions shall be the larger of the specified strength plus the standard deviation multiplied by 1.34 or the specified strength plus the standard deviation multiplied by 2.33 minus 500.

1.4.2.2 Test Records Less Than 29

Where a concrete production facility does not have test records meeting the above requirements but does have a record based on 15 to 29 consecutive tests, a standard deviation may be established as the product of the calculated standard deviation and a modification factor from the following table:

No. of tests (1)	Modification factor for standard deviation
less than 15	See Note
15	1.16
20	1.08
25	1.03
30 or more	1.00

(1) Interpolate for intermediate numbers of tests.

When a concrete production facility does not have field strength test records for calculation of standard deviation or the number of tests is less than 15, the required average strength shall be:

a. The specified strength plus 1000 specified strength of less than 3000 psi.

b. The specified strength plus 1200 for specified strengths of 3000 to 5000 psi.

c. The specified strength plus 1400 for specified strengths greater than 5000 psi.

1.5 STORAGE OF MATERIALS

Reinforcing bars and accessories shall be stored above the ground on platforms, skids or other supports. Other materials shall be stored in such a manner as to avoid contamination and deterioration. Admixtures which have been in storage at the project site for longer than 6 months or which have been subjected to freezing shall not be used unless retested and proven to meet the specified requirements.

PART 2 - PRODUCTS

2.1 ADMIXTURES

Admixtures shall conform to the following:

2.1.1 Air-Entraining Admixture

ASTM C 260.

2.1.2 Flowing Concrete Admixture

ASTM C 1017, Type 1 or 2.

2.1.3 Water-Reducing or Retarding Admixture

ASTM C 494, Type A, B, D, F, or G.

2.2 CEMENTITIOUS MATERIALS

Cementitious materials shall each be of one type and from one source when used in concrete which will have surfaces exposed in the finished structure. Cementitious materials shall conform to one of the following:

2.2.1 Cement

ASTM C 150, Type I, low alkali with the alkali content not exceeding 0.6 percent.

2.2.2 Portland-Pozzolan Cement

ASTM C 595, Type IP, IP (MS) or IP (MH).

2.2.3 Pozzolan

ASTM C 618, Class F, C or N. Pozzolan may be blended with Type I or II portland cement. When a pozzolan is used in a flexural strength concrete mix design, the solid volume of pozzolan when combined with portland cement shall not exceed 25 percent of the solid volume of portland cement plus pozzolan. Only one class of pozzolan, from a single source, shall be used.

2.3 AGGREGATES

Aggregates shall conform to the following:

2.3.1 Normal Weight Aggregate

ASTM C 33.

Coarse aggregate shall be well graded from fine to coarse within prescribed limits. Maximum nominal coarse aggregate size shall be 1-1/2 inches except as follows:

(a) Nominal maximum size of aggregate shall be not larger than 1/5 the narrowest dimension between the sides of the forms of the member for which concrete is to be used nor larger than 3/4 the minimum clear spacing between bars.

(b) Nominal maximum size of aggregate shall be not larger than 1/4 the slab thickness and shall not exceed 1-1/2 inches for slabs over 6 inches thick.

2.4 CURING MATERIALS

2.4.1 Burlap

FS CCC-C-467.

2.4.2 Impervious Sheets

ASTM C 171, type optional, except that polyethylene film, if used, shall be white opaque.

2.5 EMBEDDED ITEMS

Embedded items shall be of the size and type indicated or as needed for the application. Inserts for shelf angles and bolt hangers shall be of malleable iron or cast or wrought steel.

2.6 NONSHRINK GROUT

Nonshrink grout shall conform to ASTM C 1107 Grade A and shall be a formulation suitable for the application.

2.7 NONSLIP SURFACING MATERIAL

Nonslip surfacing material shall consist of fifty-five percent, minimum, aluminum oxide or silicon-dioxide abrasive ceramically bonded together to form a homogenous material sufficiently porous to provide a good bond with portland paste; or factory-graded emery material consisting of not less than 45 percent aluminum oxide and 25 percent ferric oxide. The material shall be well graded from particles retained on the No. 30 sieve to particles passing the No. 8 sieve.

2.8 VAPOR BARRIER

Vapor barrier shall be polyethylene sheeting with a minimum thickness of 6 mils or other equivalent material having a vapor permeance rating not exceeding 0.5 perms as determined in accordance with ASTM E 96.

2.9 WATER

Water shall be potable. Water for curing shall not contain any substance injurious to concrete, or which causes staining.

PART 3 - EXECUTION

3.1 PREPARATION OF SURFACES

Surfaces to receive concrete shall be clean and free from frost, ice, mud, and water. Conduit and other similar items shall be in place and clean of any deleterious substance.

3.1.1 Foundations

Earthwork shall be as specified in Section 02221 EXCAVATION, FILLING, AND BACKFILLING FOR BUILDINGS. Flowing water shall be diverted without washing over freshly deposited concrete. Semiporous subgrades for foundations and footings shall be damp when concrete is placed.

3.1.2 Vapor Barrier

Unless otherwise indicated, subgrades for slabs in buildings shall be covered with a vapor barrier. Vapor barrier shall be placed over the capillary water barrier. Vapor barrier edges shall be lapped at least 4 inches and ends shall be lapped not less than 6 inches. Patches and lapped joints shall be sealed with pressure-sensitive adhesive or tape not less than 2 inches wide and compatible with the membrane.

3.1.3 Preparation of Previously Placed Concrete

Concrete surfaces to which other concrete is to be bonded shall be roughened in an approved manner that will expose sound aggregate uniformly without damaging the concrete. Laitance and loose particles shall be removed. Surfaces shall be moist but without free water when concrete is placed.

3.2 INSTALLATION OF EMBEDDED ITEMS

Embedded items shall be free from oil, loose scale or rust, and paint. Embedded items shall be installed at the locations indicated and required to serve the intended purpose. Voids in sleeves, slots and inserts shall be filled with readily removable material to prevent the entry of concrete.

3.3 BATCHING, MIXING AND TRANSPORTING CONCRETE

Ready-mixed concrete shall be batched, mixed and transported in accordance with ASTM C 94, except as otherwise specified. Truck mixers, agitators, and nonagitating units shall comply with NRMCA TMMB. Ready-mix plant equipment and facilities shall be certified in accordance with NRMCA QC 3.

3.3.1 Admixtures

Admixtures shall be batched within an accuracy of 3 percent. Where two or more admixtures are used in the same batch, they shall be batched separately and must be compatible. Retarding admixture shall be added within one minute after addition of water is complete or in the first quarter of the required mixing time, whichever is first. Superplasticizing admixtures shall be added as recommended by manufacturer. Concrete that shows evidence of total collapse or segregation caused by the use of admixture shall be removed from the site.

3.3.2 Control of Mixing Water

No water from the truck system or elsewhere shall be added after the initial introduction of mixing water for the batch except when on arrival at the jobsite, the slump of the concrete is less than that specified. Water added to bring the slump within the specified range shall not change the total water in the concrete to a point that the approved water-cement ratio is exceeded. The drum shall be turned an additional 30 revolutions, or more, if necessary, until the added water is uniformly mixed into the concrete. Water shall not be added to the batch at any later time.

3.4 SAMPLING AND TESTING DURING CONSTRUCTION

Sampling and Testing is the responsibility of the Contractor and shall be performed by an approved testing agency.

3.4.1 Sampling of Concrete

Samples of concrete for air, slump, and strength tests shall be taken in accordance with ASTM C 172.

3.4.1.1 Air Content

Test for air content shall be performed in accordance with ASTM C 173 or ASTM C 231. A minimum of 1 test per day shall be conducted for each pour of air-entrained concrete.

3.4.1.2 Slump

At least 2 slump tests shall be made on randomly selected batches of each mixture of concrete during each day's concrete placement. Tests shall be performed in accordance with ASTM C 143.

3.4.2 Evaluation and Acceptance of Concrete

3.4.2.1 Frequency of Testing

Samples for strength tests of each class of concrete placed each day shall be taken not less than once a day, nor less than once for each 150 cubic yards of concrete, nor less than once for each 5000 square feet of surface area for slabs or walls. If this sampling frequency results in less than 5 strength tests for a given class of concrete, tests shall be made from at least 5 randomly selected trucks or from each truck if fewer than 5 truck loads are used. Field cured specimens for determining form removal time or when a structure may be put in service shall be made in numbers directed to check the adequacy of curing and protection of concrete in the structure. The specimens shall be removed from the molds at the age of 24 hours and shall be cured and protected, insofar as practicable, in the same manner as that given to the portion of the structure the samples represent.

3.4.2.2 Testing Procedures

Cylinders for acceptance tests shall be molded and cured in accordance with ASTM C 31. Cylinders shall be tested in accordance with ASTM C 39. A strength test shall be the average of the strengths of two cylinders made from the same sample of concrete and tested at 28 days or at another specified test age.

3.4.2.3 Evaluation of Results

Concrete specified on the basis of compressive strength will be considered satisfactory if the averages of all sets of three consecutive strength test results equal or exceed the specified strength and no individual strength test result falls below the required strength by more than 500 pounds per square inch.

3.4.3 Investigation of Low-Strength Test Results

When any strength test of standard-cured test cylinder falls below the specified strength requirement by more than 500 pounds per square inch, or if tests of field-cured cylinders indicate deficiencies in protection and curing, steps shall be taken to assure that load-carrying capacity of the structure is not jeopardized. Nondestructive testing in accordance with ASTM C 597, ASTM C 803 or ASTM C 805 may be permitted by the Contracting Officer to determine the relative strengths at various locations in the structure as an aid in evaluating concrete strength in place or for selecting areas to be cored. Such tests, however, shall not be used a basis for acceptance or rejection. When strength of concrete in place is considered potentially deficient, cores shall be obtained and tested in accordance with ASTM C 42. At least three representative cores shall be taken from each member or area of concrete in place that is considered potentially deficient. The location of cores shall be determined by the Contracting Officer to least impair the strength of the structure. If the concrete in the structure will be dry under service conditions, the cores shall be air dried (temperature 60 to 80 degrees F, relative humidity less than 60 percent) for seven days before testing and shall be tested dry. If the concrete in the structure will be more than superficially wet under service conditions, the cores shall be tested after moisture conditioning in accordance with ASTM C 42. Concrete in the area represented by the core testing will be considered adequate if the average strength of the cores is equal to or at least 85 percent of the specified strength requirement and if no single core is less than 75 percent of the specified strength requirement. If the core tests are inconclusive or impractical to obtain, or if structural analysis does not confirm the safety of the structure, load tests may be directed by the Contracting Officer in accordance with the requirements of ACI 318. Concrete work evaluated by structural analysis or by results of a load test and found deficient shall be corrected in a manner satisfactory to the Contracting Officer. All investigations, testing, load tests, and correction of deficiencies shall be performed, and approved by the Contracting Officer, at the expense of the Contractor.

3.5 CONVEYING CONCRETE

Concrete shall be conveyed from mixer to forms as rapidly as possible and within the time interval specified in paragraph CONCRETE PLACEMENT by methods which will prevent segregation or loss of ingredients.

3.5.1 Chutes

When concrete can be placed directly from a truck mixer or other transporting equipment, chutes attached to this equipment may be used. Separate chutes will not be permitted except when specifically approved.

3.5.2 Buckets

Bucket design shall be such that concrete of the required slump can be readily discharged. Bucket gates shall be essentially grout tight when closed. The bucket shall provide means for positive regulations of the amount and rate of deposit of concrete in each dumping position.

3.5.3 Belt Conveyors

Belt conveyors may be used when approved. Belt conveyors shall be designed for conveying concrete and shall be operated to assure a uniform flow of concrete to the final place of deposit without segregation or loss of mortar. Conveyors shall be provided with positive means for preventing segregation of the concrete at transfer points and point of placement.

3.5.4 Pumps

Concrete may be conveyed by positive displacement pumps when approved. Pump shall be the piston or squeeze pressure type. Pipeline shall be steel pipe or heavy duty flexible hose. Inside diameter of the pipe shall be at least three times the maximum size of the coarse aggregate. Distance to be pumped shall not exceed the limits recommended by the pump manufacturer. Concrete shall be supplied to the pump continuously. When pumping is completed, the concrete remaining in the pipeline shall be ejected without contaminating the concrete in place. After each use, the equipment shall be thoroughly cleaned. Flushing water shall be wasted outside the forms.

3.6 CONCRETE PLACEMENT

Mixed concrete which is transported in truck mixers or agitators or concrete which is truck mixed, shall be discharged within 1-1/2 hours or before the drum has revolved 300 revolutions, whichever comes first after the introduction of the mixing water to the cement and aggregates or the introduction of the cement to the aggregates. These limitations may be waived by the Government if the concrete is of such slump after the 1-1/2 hour time or 300 revolution limit has been reached that it can be placed, without the addition of water to the batch. When the concrete temperature exceeds 85 degrees F, the time shall be reduced to 45 minutes. Concrete shall be placed within 15 minutes after it has been discharged from the truck.

3.6.1 Placing Operation

Concrete shall be handled from mixer to forms in a continuous manner until the approved unit of operation is completed. Adequate scaffolding, ramps and walkways shall be provided so that personnel and equipment are not supported by in-place reinforcement. Placing will not be permitted when the sun, heat, wind, or limitations of facilities furnished by the Contractor prevent proper consolidation, finishing and curing. Concrete shall be deposited as close as possible to its final position in the forms, and there shall be no vertical drop greater than 8 feet except where suitable equipment is provided to prevent segregation and where specifically authorized. Depositing of the concrete shall be so regulated that it will be effectively consolidated in horizontal layers not more than 24 inches thick, except that all slabs shall be placed in a single layer. Concrete to receive other construction shall be screeded to the proper level to avoid excessive shimming or grouting.

3.6.2 Consolidation

Immediately after placing, each layer of concrete shall be consolidated by internal vibrators, except for slabs 4 inches or less. The vibrators shall at all times be adequate in effectiveness and number to properly consolidate the concrete; a spare vibrator shall be kept at the jobsite during all concrete placing operations. The vibrators shall have a frequency of not less than 8000 vibrations per minute, and the head diameter and amplitude

shall be appropriate for the concrete mixture being placed. Vibrators shall be inserted vertically at uniform spacing over the area of placement. The distance between insertions shall be approximately 1-1/2 times the radius of action of the vibrator so that the area being vibrated will overlap the adjacent just-vibrated area by a few inches. The vibrator shall penetrate rapidly to the bottom of the layer and at least 6 inches into the preceding layer if there is such. Vibrator shall be held stationary until the concrete is consolidated and then withdrawn slowly. The use of form vibrators must be specifically approved. Vibrators shall not be used to transport concrete within the forms. Slabs 4 inches and less in thickness shall be consolidated by properly designed vibrating screeds or other approved technique. Excessive vibration of lightweight concrete resulting in segregation and flotation of coarse aggregate shall be avoided.

3.6.3 Cold Weather Requirements

Special protection measures, approved by the Contracting Officer, shall be used if freezing temperatures are anticipated before the expiration of the specified curing period. The ambient temperature of the air where concrete is to be placed and the temperature of surfaces to receive concrete shall be not less than 40 degrees F. The temperature of the concrete when placed shall be not less than 50 degrees F nor more than 75 degrees F. Heating of the mixing water or aggregates will be required to regulate the concrete placing temperature. Materials entering the mixer shall be free from ice, snow, or frozen lumps. Salt, chemicals or other materials shall not be incorporated in the concrete to prevent freezing. Upon written approval, calcium chloride or chemical admixture conforming to ASTM C 494 Type C or E may be used. The amount of calcium chloride shall not exceed 2 percent by weight of the cement, and it shall be batched in solution form. Calcium chloride shall not be used where concrete will be in contact with aluminum or zinc-coated items, or where sulfate resistant or prestressed concrete is specified.

3.6.4 Warm Weather Requirements

Concrete shall be placed in accordance with ACI 305R. During periods of warm weather, the following precautions shall be taken to prevent the formation of plastic-shrinkage cracks resulting from excessive loss of moisture from the concrete:

a. The metal forms and/or underlying base or subgrade materials that will not be covered by vapor barrier or similar material shall be cooled by sprinkling or fogging with water immediately before the placement of concrete.

b. All concrete shall be delivered to the forms at a temperature below 85 degrees F., except that concrete with retarding admixtures may have temperatures of 85 ° to 90 ° F as deposited in the forms.

c. Placement may be allowed only at night or in early morning hours if necessary to maintain the concrete temperature and keep forms cool.

d. The concrete shall be placed and finished as rapidly as practicable and curing will start immediately after final finishing has been completed on any section of a floor or placement.

e. The finished surface of the concrete shall be kept damp by applying a water fog or mist with approved spraying equipment until mats can be applied as required by the moist curing method.

f. Curing for the first 24 hours after placement shall be by the moist curing method.

3.7 CONSTRUCTION JOINTS

Construction joints shall be located as indicated or approved. Where concrete work is interrupted by weather, end of work shift or other similar type of delay, location and type of construction joint shall be subject to approval of the Contracting Officer. Unless otherwise indicated and except for slabs on grade, reinforcing steel shall extend through construction joints.

3.8 FINISHING CONCRETE

3.8.1 Formed Surfaces

3.8.1.1 Repair of Surface Defects

Surface defects shall be repaired within 24 hours after the removal of forms. Honeycombed and other defective areas shall be cut back to solid concrete or to a depth of not less than 1 inch, whichever is greater. Edges shall be cut perpendicular to the surface of the concrete. The prepared areas shall be dampened and brush-coated with neat cement grout. The repair shall be made using mortar consisting of not more than 1 part cement to 2-1/2 parts sand. The mixed mortar shall be allowed to stand to stiffen (approximately 45 minutes), during which time the mortar shall be intermittently remixed without the addition of water. After the mortar has attained the stiffest consistency that will permit placing, the patching mix shall be thoroughly tamped into place by means approved by the Contracting Officer and finished slightly higher than the surrounding surface. For Class B finished surfaces the cement used in the patching mortar shall be a blend of job cement and white cement proportioned to produce a finished repair surface matching, after curing, the color of adjacent surfaces. Holes left after the removal of form ties shall be cleaned and filled with patching mortar. Holes left by the removal of tie rods shall be reamed and filled by dry-packing. Repaired surfaces shall be cured as required for adjacent surfaces. The temperature of concrete, mortar patching material, and ambient air shall be above 50 degrees F while making repairs and during the curing period. Concrete with defects which affect the strength of the member or with excessive honeycombs will be rejected, or the defects shall be corrected as directed.

3.8.1.2 Class A Finish

Class A finish shall not be used.

3.8.1.3 Class B Finish

Class B finish shall be used at all formed surfaces exposed to view. Fins shall be removed. Concrete surface shall be smooth with a texture at least equal to that obtained through the use of Grade B-B plywood forms.

3.8.1.4 Class C Finish

Class C finish shall not be used.

3.8.1.5 Class D Finish

Class D finish shall be used for all surfaces not exposed to view. Fins exceeding 1/4 inch in height shall be chipped or rubbed off. Concrete surfaces shall be left with the texture imparted by the forms used.

3.8.2 Unformed Surfaces

In cold weather, the air temperature in areas where concrete is being finished shall not be less than 50 degrees F. In hot windy weather when the rate of evaporation of surface moisture, as determined by methodology presented in ACI 305R, may reasonably be expected to exceed 0.2 pounds per square foot per hour; coverings, windbreaks, or fog sprays shall be provided as necessary to prevent premature setting and drying of the surface. The dusting of surfaces with dry materials or the addition of water during finishing will not be permitted. Finished surfaces shall be plane, with no deviation greater than 5/16 inch when tested with a 10-foot straightedge. Floor tolerance measurements shall be made as soon as possible after finishing. When forms or shoring are used the measurements shall be made prior to their removal. Surfaces shall be pitched to drains.

3.8.2.1 Float Finish

Slabs to receive a steel trowel finish shall be given a float finish. Screeding shall be followed immediately by darbying or bull floating before bleeding water is present, to bring the surface to a true, even plane. After the concrete has stiffened to permit the operation and the water sheen has disappeared, it shall be wood floated. Concrete that portrays stickiness shall be finished with a magnesium float in lieu of a wood float, and left free of ridges and other projections.

Float finish is normally specified for surfaces that will receive other treatment such as built-up roofing, nonslip surfacing material or other types of dry-shake surface. It should not be specified as a wearing surface.

3.8.2.2 Trowel Finish

Apply trowel finish to monolithic slab surfaces to be exposed to view and slab surfaces to be covered with resilient flooring, carpet, ceramic or quarry tile Apply trowel finish immediately following floating. Surfaces shall be trowelled to produce smooth, dense slabs free from blemishes including trowel marks. In lieu of hand finishing, an approved power finishing machine may be used in accordance with the directions of the machine manufacturer. A final hard steel troweling shall be done by hand.

Trowel finish will be specified for most wearing surfaces and where a smooth finish is required.

3.8.2.3 Broom Finish

Broom finish will be given to equipment pads, steps, landings and ramps, and the slab surface at the mechanical room. After floating, slabs shall be lightly trowelled, and then broomed with a fiber-bristle brush in a direction transverse to that of the main traffic.

3.9 CURING AND PROTECTION

3.9.1 General

All concrete shall be cured by an approved method for the period of time given below:

Concrete with Type I, cement	7 days
Concrete with Type I cement blended with pozzolan	7 days

Immediately after placement, concrete shall be protected from premature drying extremes in temperatures, rapid temperature change, mechanical injury and injury from rain and flowing water. Air and forms in contact with concrete shall be maintained at a temperature above 50 degrees F for the first 3 days and at a temperature above 32 degrees F for the remainder of the specified curing period. Exhaust fumes from combustion heating units shall be vented to the outside of the enclosure and heaters and ducts shall be placed and directed so as not to cause areas of overheating and drying of concrete surfaces or to create fire hazards. All materials and equipment needed for adequate curing and protection shall be available and at the site prior to placing concrete. No fire or excessive heat shall be permitted near or in direct contact with the concrete at any time. Curing shall be accomplished by the moist curing method.

3.9.2 Moist Curing

Concrete to be moist-cured shall be maintained continuously wet for the entire curing period. If water or curing materials used stains or discolors concrete surfaces which are to be permanently exposed, the concrete surfaces shall be cleaned. When wooden forms are left in place during curing, they shall be kept wet at all times. If the forms are removed before the end of the curing period, curing shall be carried out as on unformed surfaces, using suitable materials. Horizontal surfaces shall be cured by ponding, by covering with a 2-inch minimum thickness of continuously saturated sand, or by covering with waterproof paper, polyethylene sheet, polyethylene-coated burlap or saturated burlap.

3.10 SETTING BASE PLATES AND BEARING PLATES

After being properly positioned, column base plates, bearing plates for beams and similar structural members, and machinery and equipment base plates shall be set to the proper line and elevation with damp-pack bedding mortar, except where nonshrink grout is indicated. The thickness of the mortar or grout shall be approximately 1/24 the width of the plate, but not less than 3/4 inch. Concrete and metal surfaces in contact with grout shall be clean and free of oil and grease, and concrete surfaces in contact with grout shall be damp and free of laitance when grout is placed.

3.10.1 Damp-Pack Bedding Mortar

Damp-pack bedding mortar shall consist of 1 part cement and 2-1/2 parts fine aggregate having water content such that a mass of mortar tightly squeezed in the hand will retain its shape but will crumble when disturbed. The space between the top of the concrete and bottom of the bearing plate or base shall be packed with the bedding mortar by tamping or ramming with a bar or rod until it is completely filled.

3.10.2 Nonshrink Grout

Nonshrink grout shall be mixed and placed in accordance with material manufacturer's written recommendations. Forms of wood or other suitable material shall be used to retain the grout. The grout shall be placed quickly and continuously, completely filling the space without segregation or bleeding of the mix.

3.10.3 Treatment of Exposed Surfaces

For metal-oxidizing nonshrink grout, exposed surfaces shall be cut back 1 inch and immediately covered with a parget coat of mortar consisting of 1 part portland cement and 2-1/2 parts fine aggregate by weight, with sufficient water to make a plastic mixture. The parge coat shall have a smooth finish. For other mortars or grouts, exposed surfaces shall be left untreated. Curing shall comply with paragraph CURING AND PROTECTION.

- - o 0 o - -